

Date: Friday, 16/05/2008 8:45:37 AM
 User: Julie Lecocq

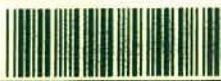
Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING LUG	
Job Number	: 39315		Part Number	: D22301	
Estimate Number	: 10255		Drawing Number	: D2230 REV F	
P.O. Number	:		Project Number	: N/A	
This Issue	: 16/05/2008 S.O. No. :		Drawing Revision	: F	
Prsht Rev.	: NC		Material	:	
First Issue	: / /		Due Date	: 30/05/2008	
Previous Run	: 39137		Qty:	200 Um: Each	
Written By	:			300	
Checked & Approved By	: JUD 08.5.16				
Comment	: Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2423	Lug Extrusion	
		Comment: Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s) Lug Extrusion D2423 Extrusion Batch: B33310	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut D2423 extrusion to 0.82" Batch:	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per lot no D2230-1 (Check for crack while loading into the machine.) 2-Tumble and deburr rough edges after tumbling	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Receive & inspect for visual damage Ensure C/S/C attached	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC5	SECOND CHECK	
		Comment: SECOND CHECK Inspect level 5	

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: MOUNTING LUG
Job Number: 39315		Part Number: D22301
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		<i>m-1/12/10</i> 08/06/10 (215)
7.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		<i>5 08/06/10 (215)</i>
8.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3		<i>m10 7925</i> 2B
START TIME:	3:15 PM	
OVEN TEMPERATURE:	320	
FINISH TIME:	3:45 PM	<i>2/1/10 08/06/11</i>
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		<i>FL 08/06/12</i> (215)
10.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location:		<i>P 8/6/16 (215)</i>
11.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		<i>08/06/16 (215)</i>
Job Completion 		<i>U 08/06/16</i>

DART AEROSPACE LTD	Work Order:	39315
Description: Mounting Lug	Part Number:	D2230-1
Inspection Dwg: D2230	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by: _____
Date: _____

Audited by:	
Date:	

Prototype Approval:	N/A
Date:	

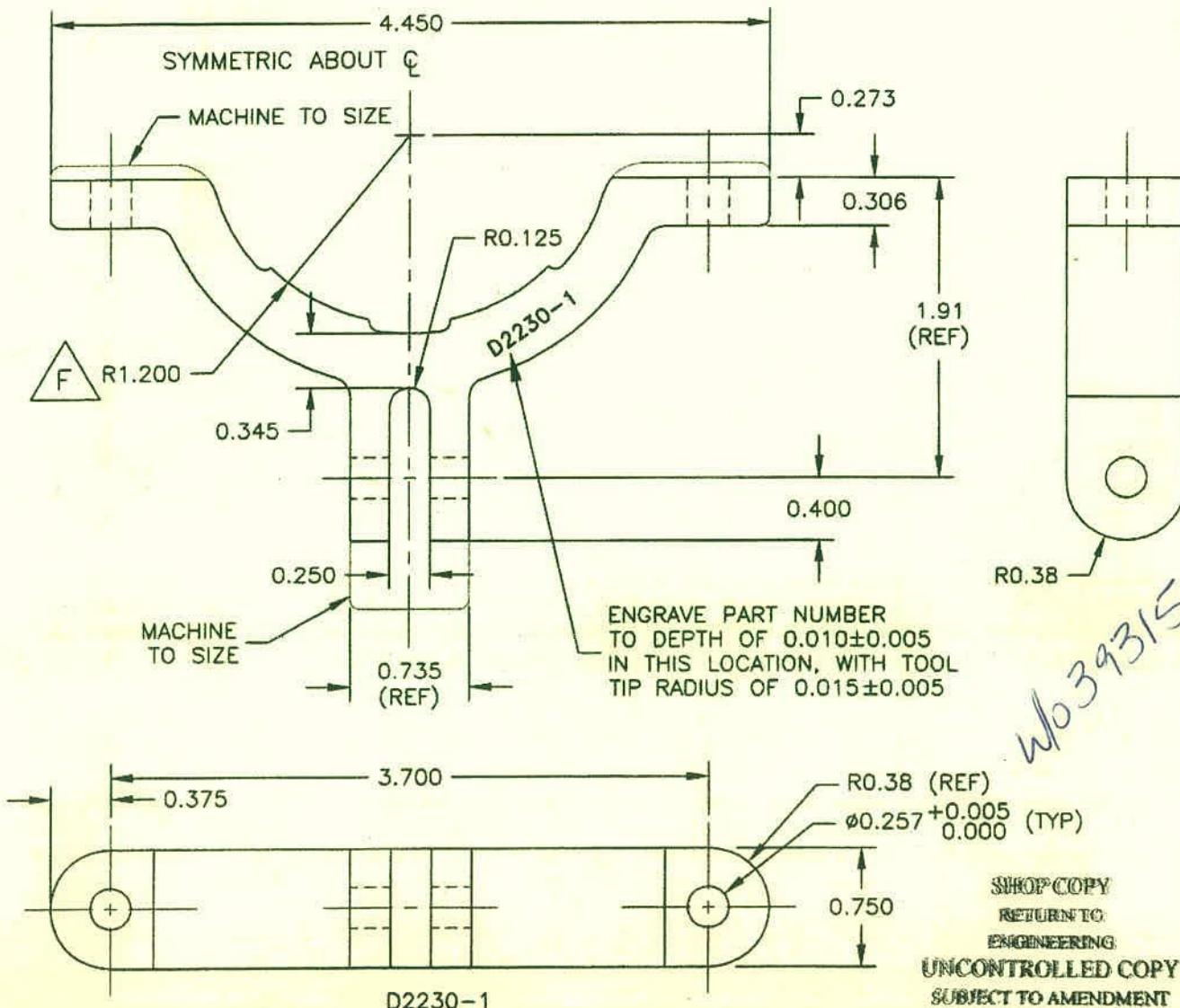
Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	FF

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230 REV. F SHEET 1 OF 2
DATE		TITLE MOUNTING LUG
99.12.13		SCALE 1:1
C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

RELEASED

99.12.21 DS



SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 31315

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

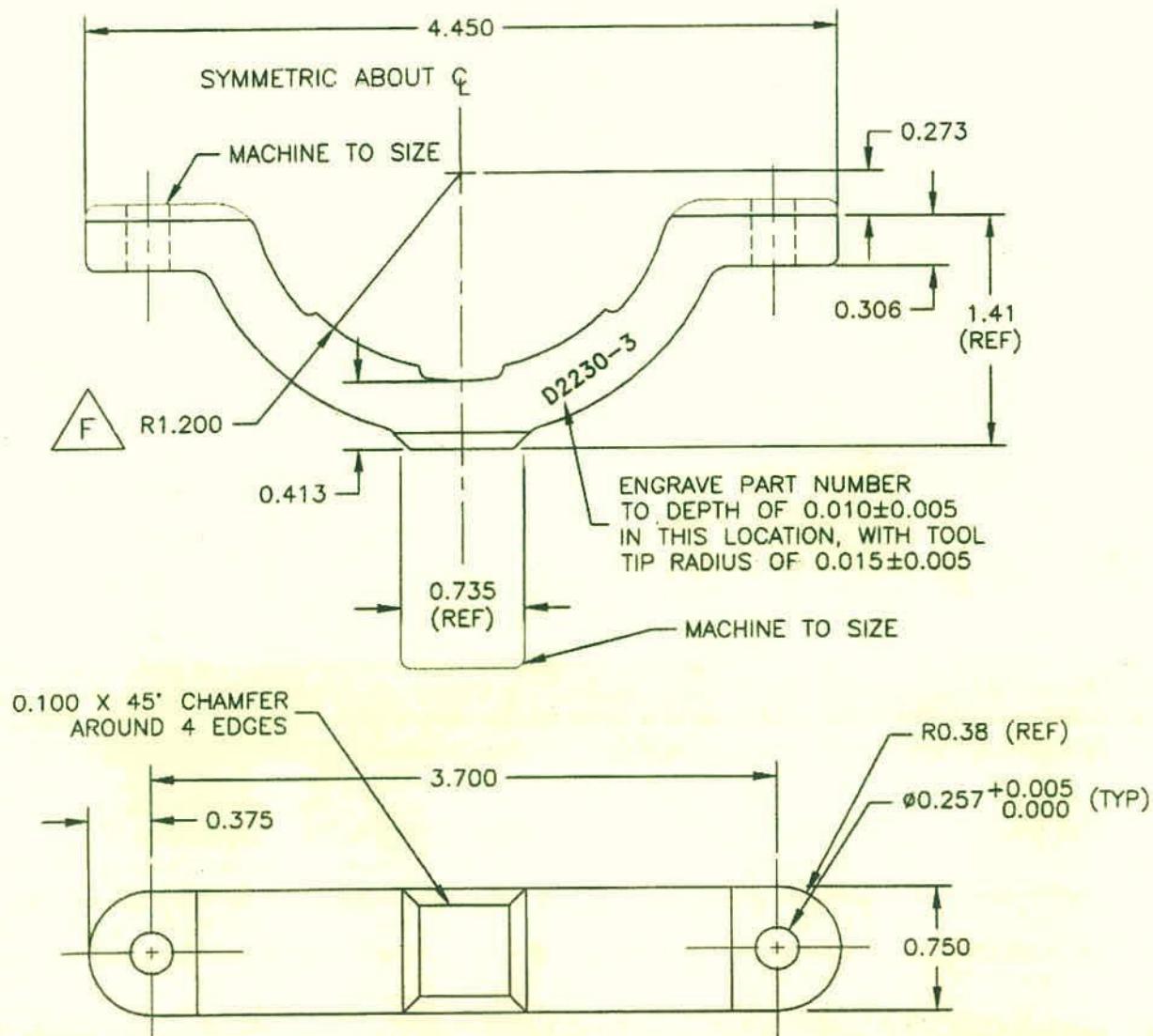
DARTCOPY ISSUED
ON

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230 REV. F SHEET 2 OF 2
DATE		TITLE MOUNTING LUG SCALE 1:1

99.12.13

RELEASED

79.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 39315

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
215	D2230-1	Mounting Lug B39315	6387
	MATERIAL: supplied by DART	D2423 B33310	

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.



Denise Robinson

Vankleek Hill, June 9, 2008

